



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2279
Job Sheet 213247



Part No: D2279

Job Qty: 10 pcs

DAS
21
9-89

Part Name: Step Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/21/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/28/20

Description: SIOP

Type: Stock

Note: DWG REV D IPP Rev: A New Issue 05-11-07 JLM IPP Rev: B Now on Waterjet 06-07-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		10/27/20	0.17	0.53	Waterjet - Flow		<i>on 20/10/27</i>
120	QC 8	10 pcs		10/27/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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125 Small Fab - 2 - B4B	10 pcs	10/27/20	0.00 0.17	QC 8 - 82	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	OCT 28 2020
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
130 Small Fab - Brake NC - B4B	10 pcs	10/27/20	0.25 0.10	Small Fab - Various 1 - B4B	
				Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
140 QC 5	10 pcs	10/27/20	0.00 0.00	Small Fab - Brake - 3 - B4B	OCT 28 2020
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 29 2020
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	10 pcs	10/28/20	0.00 0.21	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

160 QC 7	10 pcs	10/28/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
170 Packaging 3-1 - Stock - B4B	10 pcs <i>12 pcs MAD</i>	10/28/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

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					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	10 pcs	10/28/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 9	21	
				QC 21 - SA - 77	9-30	
				QC 21 - SA - 28		NOV 06 2020

Part Op 100 - 1-Cut as per Dwg
 Descriptions: 120 - (QC8- Inspect parts - second check)
 125 - FORM FLANGE AS PER DWG USING DT8174
 130 - Bend as per Dwg D2279
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.4700 sf (.147 ea)	100-Waterjet - Flow - 1	S153359

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	1	82	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250Inches ± 0.005	0.255 0.245	.249	
2	Step Spacer	2.214Inches ± 0.005	2.219 2.209	2.212	
3	Step Spacer	4.178Inches ± 0.005	4.183 4.173	4.179	
4	Step Spacer	4.428Inches ± 0.010	4.438 4.418	4.429	
5	Step Spacer	0.250Inches ± 0.005	0.255 0.245	.251	
6	Step Spacer	1.313Inches ± 0.005	1.318 1.308	1.312	
7	Step Spacer	3.313Inches ± 0.005	3.318 3.308	3.314	
8	Step Spacer	4.625Inches ± 0.010	4.635 4.615	4.628	
9	Step Spacer	0.128Inches + 0.005 -0.000	0.133 0.128	.130	Diameter
10	Step Spacer	1.250Inches + 0.005 -0.000	1.255 1.250	1.249	Diameter
11	Step Spacer	0.125Inches ± 0.010	0.135 0.115	.125	Radius

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

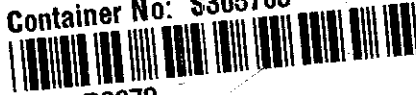
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S308705



Part: D2279

Job No: 213247

Serial No/Batch: S308705

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Newkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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